

•Date: Wednesday, 29/04/2009 3:02:16 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT WINDOW ASSEMBLY	
Job Number :	47611			
Estimate Number :	11174			
P.O. Number :		Part Number :	D3290041	
This Issue :	29/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3290 REV C	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	45816	Drawing Revision :	C	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	05/05/2009	Qty: 6 Um: Each
Written By :				
Checked & Approved By :	<u>JUD 09.04.29</u>			
Comment :	Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM Est rev E rev C dwg 07.09.28 EC verified by: DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 3.9375 sf(s)/Unit Total : 23.6250 sf(s)

M6061T6S040

Batch: 111224 B9-S-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: CProg Rev: CB9-S-26

⑥

2-Deburr if necessary

B9-S-268/09/05/27 ⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B9-S-26**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK5/05/27 ⑥

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YMD 09/05/27 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:02:16 PM
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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 47611

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00am

01

09-05-22

X6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/27

6

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 39.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal

B42154 ③

B48285 ③

SAD

09-06-15

6

09-05-28

③

9.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3

Window

43903 3X
47693 3X

3X

09-06-15

09-06-15

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 09-06-15

SAD 09-05-28

③

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/15

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:02:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 47611

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



16x

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 219

9/6/16

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47661
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

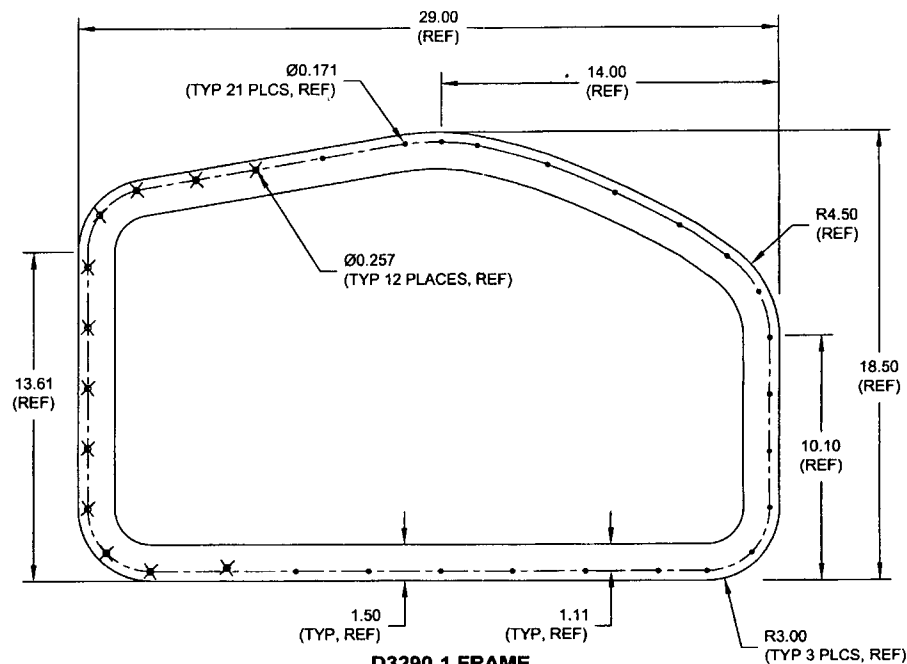
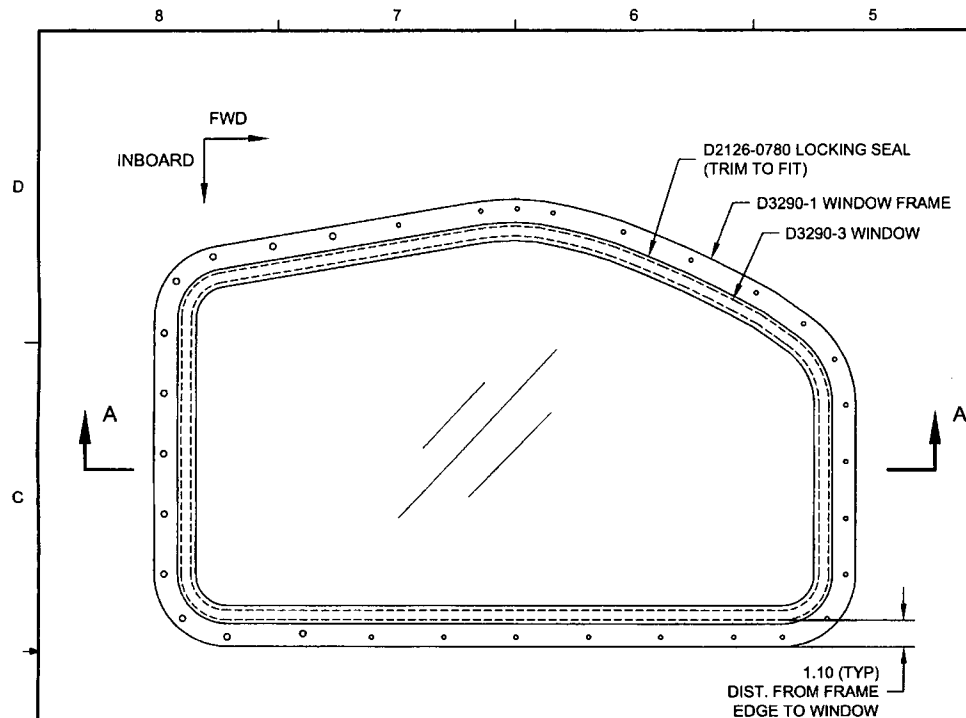
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	X			
14.00	+/-0.030	14.00	X			
Ø0.171	+0.005/-0.001	.173	*			
1.50	+/-0.030	1.507	*			
1.11	+/-0.030	1.11	*			
10.10	+/-0.030	10.10	X			
18.50	+/-0.030	18.50	X			
0.040	+/-0.010	.038	*			
R3.00	+/-0.030	3.00	*			
R4.50	+/-0.030	4.56	*			
Ø0.257	+0.006/-0.001	.259	*			
13.61	+/-0.030	13.61	X			

Measured by: IB	Audited by: E	Prototype Approval:	N/A
Date: 9-5-26	Date: 09/15/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	

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WORK ORDER
NO.



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24

D2126-0780 LOCKING SEAL
(REF)

ENSURE D3290-3 WINDOW IS INSTALLED
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

SECTION A-A
NTS

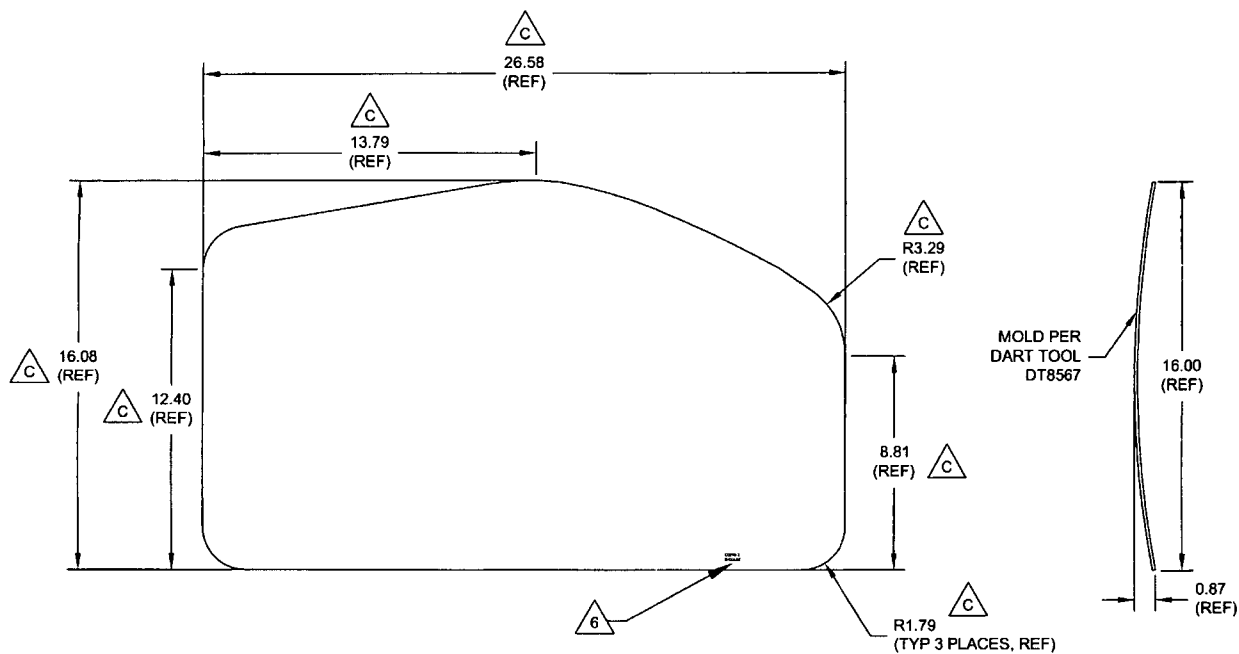
D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED
07.07.22

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CHECKED		DRAWING NO.	REV. C
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